



Dart Aerospace Ltd.
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D3913-041
Job Sheet 173408



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/1/18

Job Tracking No:

Due Date: 4/23/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/20/18	0.00	0.00	Start Up Large Fab-5		DC 2018-03-28
100	Large Fab	1 pcs		4/21/18	0.00	10.00	Large Fab 1		2018-03-22
110	QC	1 pcs		4/21/18	0.00	0.00	QC9		PD 18-3-29
120	QC	1 pcs		4/21/18	0.00	0.00	QC5		18-3-29
125	HandFinish	1 pcs		4/21/18	0.00	0.29	HandFinish2		18-4-11
130	Powdercoat	1 pcs		4/21/18	0.00	0.93	Powdercoat2		18-4-5
135	Packaging	1 pcs		4/21/18	0.00	0.00	Packaging1		18-4-05
140	QC	1 pcs		4/21/18	0.00	0.00	QC3		18-4-07
150	HandFinish	1 pcs		4/23/18	0.00	0.50	HandFinish4		18-4-16
160	QC	1 pcs		4/23/18	0.00	0.00	QC5		18-4-5
170	Packaging	1 pcs		4/23/18	0.00	0.00	Packaging3-2		18-4-07
180	QC21-SA	1 Ea		4/23/18	0.00	0.00	QC21		21 APR 05 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2 Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138760. START: 8:35. OUT: 3:45 FINISH: 8:50.

Job BOM					002252
Part / Item	Component Name	Quantity	Operation	Container	
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	S042562	
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	S047253	
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	S043834	
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	S047906	
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	S048304	
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	S047279	
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	S047655	
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	S048165	
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	S036080	
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	S045854	
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	S046597	
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	S046610 S046610	
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	S047853	
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	S047783 S047783	
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	S047724	
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	S036909	
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	S049717	
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	S041477	
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	F86435	
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	S047091	
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	S0638764	
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	M1133704-227	
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	S045376	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	102	0
	D3913-1	1	4	0
	D3913-15	1	27	0
	D3913-3	1	8	0
	D3913-7	2	9	0
	D3913-9	1	4	0
	D3916-041	2	8	0
	D3916-5	3	18	0
	D4016-1	3	52	0
	D4017-7	3	81	0
	D4017-9	2	22	0
	D4020-11	2	20	0
	D4021-1	3	30	0
	D4034-041	1	7	0
	D4034-043	1	7	0
	D4672-1	2	30	0
	M304EX0.75-16F	33	442	0
150-HandFinish	AN3-10A	6	312	0
	D2931	2	1,116	0
	D4021-5	2	32	0
	MS20600-AD4W3	2	227	0
	MS21042L3	6	3,339	0
	NAS1149F0332P	12	3,223	0

Part Specifications

Specifications could not be found.

Plex 3/1/18 1:45 PM dart.logan.david

Master Unit 001712



Job No 173408



Container No: S054049



Part: D3913 - 041

Job No: 173408

Serial No/Batch: S054049

Revision:

Inspector:

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